

Date: Tuesday, 5/16/2006 10:41:10 AM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |  |                  |  |  |
|-----------------------|---------------------------------------|--|------------------|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services |  | Drawing Name     | : GAS SPRING   |  |
| Job Number            | : 27151                               |  | Part Number      | : D2807  |  |
| Estimate Number       | : 10336                               |  | Drawing Number   | : D2807 REV C  |  |
| P.O. Number           | : N/A                                 |  | Project Number   | : N/A  |  |
| This Issue            | : 5/16/2006 S.O. No. : N/A            |  | Drawing Revision | : C  |  |
| Prsht Rev.            | : NC                                  |  | Material         | : N/A  |  |
| First Issue           | : N/A                                 |  | Due Date         | : 5/30/2006 Qty: 50 Um: Each                         |  |
| Previous Run          | : 26646                               |  | Comment          | : Est: D 05.06.21 Removed painting; Changed supplier |  |
| Written By            | : KJ/JLM                              |  | Comment          |  |  |
| Checked & Approved By | : <u>06.05.16</u>                     |  | Comment          |  |  |
| Comment               |                                       |  | Comment          |  |  |

## Additional Product

Job Number:



| Seq. #:   | Machine Or Operation: | Description :         |
|---|-----------------------|-----------------------|
| 1.0   | PG                    | PURCHASING            |
|   |                       |                       |
| <b>Comment:</b> PURCHASING<br>Issue P/O: <u>1299</u><br>Order as per Dwg D2807<br>Possible supplier: ArvinMeritor Motion Control Systems<br>Material release note is required |                       |                       |
| 2.0   | SXF6S6050080S6L115N   | GAS SPRING            |
|   |                       |                       |
| <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)<br>SUPPORT PROP  |                       |                       |
| 3.0   | PACKAGING 1           | PACKAGING RESOURCE #1 |
|   |                       |                       |
| <b>Comment:</b> PACKAGING RESOURCE #1<br>Receive & Inspect for Transit Damage<br>Ensure Material Release Note is attached   |                       |                       |
| 4.0   | QC6                   | DIMENSIONAL CHECK     |
|   |                       |                       |
| <b>Comment:</b> DIMENSIONAL CHECK   |                       |                       |
| 5.0   | D28073                | Lug                   |
|   |                       |                       |
| <b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)<br>Pick:<br>2 D2807-3 Lug Batch: <u>B27563</u> <del>B26647</del> (17)<br>(83) <del>540</del> 06.07.20 50    |                       |                       |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)                          |                             |  |                            |                           |                        |                          |
|----------|------|---|-----------------------------|--|----------------------------|---------------------------|------------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A                            | Corrective Action Section B |  |                            | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|          |      |   | Initial<br>Design Mgr       | Action Description<br>Design Mgr         | Sign &<br>Date             |                           |                        |                          |
| 06/03/16 | 6    | 2 D2807-3 fit<br>not well. Threads<br>not all the way in. | SD<br>design                | removed + replace<br>it<br>Scrap D2807-3 | SB<br>06/03/16<br>06-08-16 | 2                         | AB<br>assem            | 2<br>06-08-16            |
|          |      |   |                             |  |                            |                           |                        |                          |
|          |      |   |                             |  |                            |                           |                        |                          |

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No DQA: 

Date: 06/08/16

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Tuesday, 5/16/2006 10:41:10 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 27151

Part Number: D2807

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

SB 04/08/15

50

2-Remove lettering and logo with wash and wipe. SD 06/07/20

50

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST388

SB 06/08/16

50

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/08/17

Job Completion



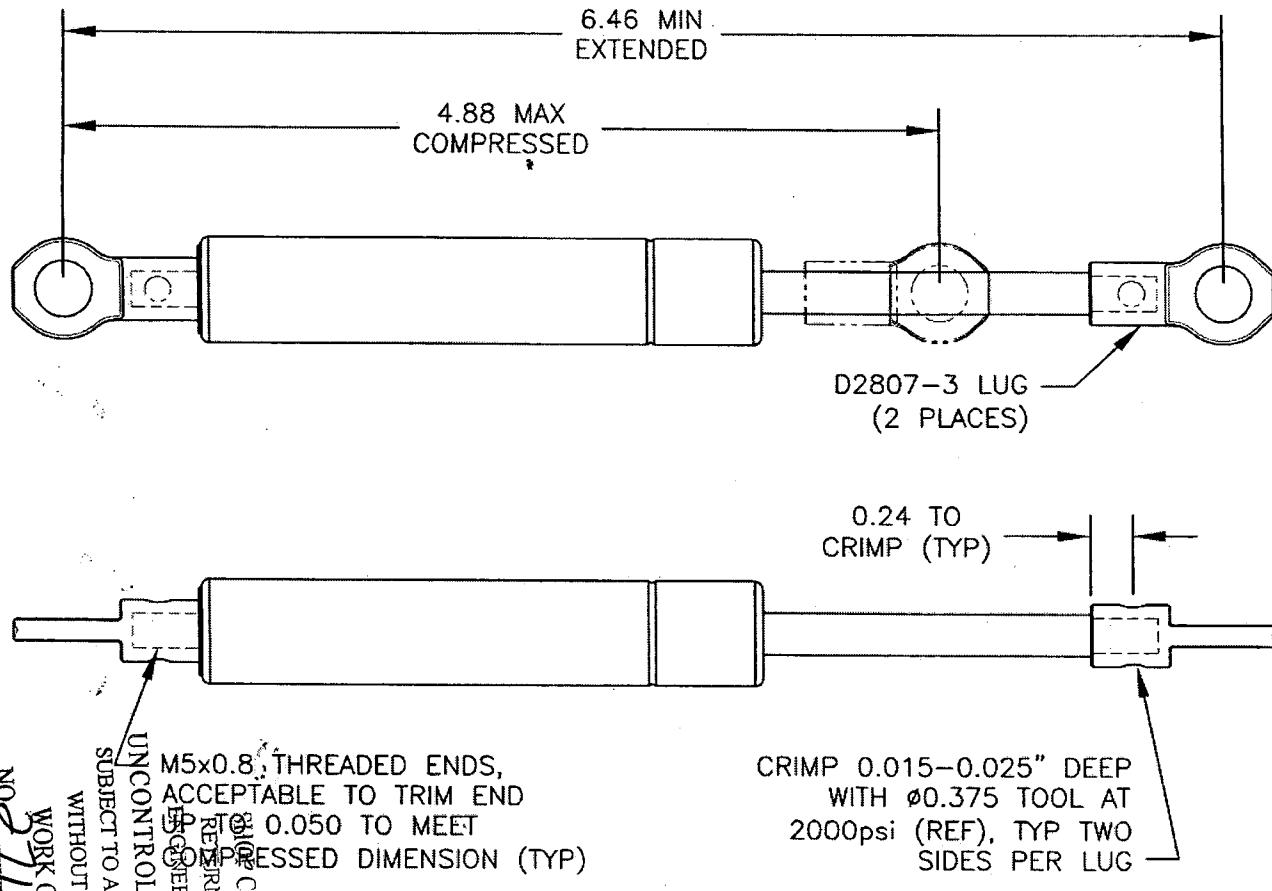
CLocc/08/17

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



### D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

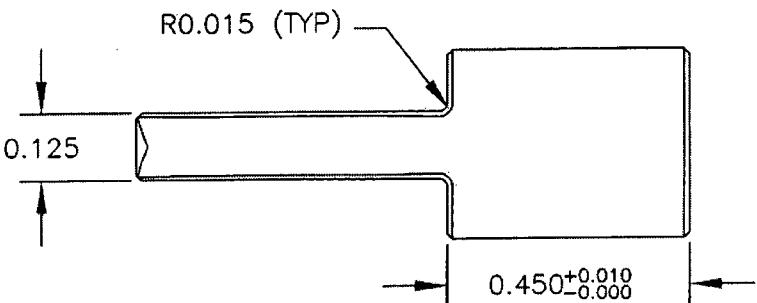
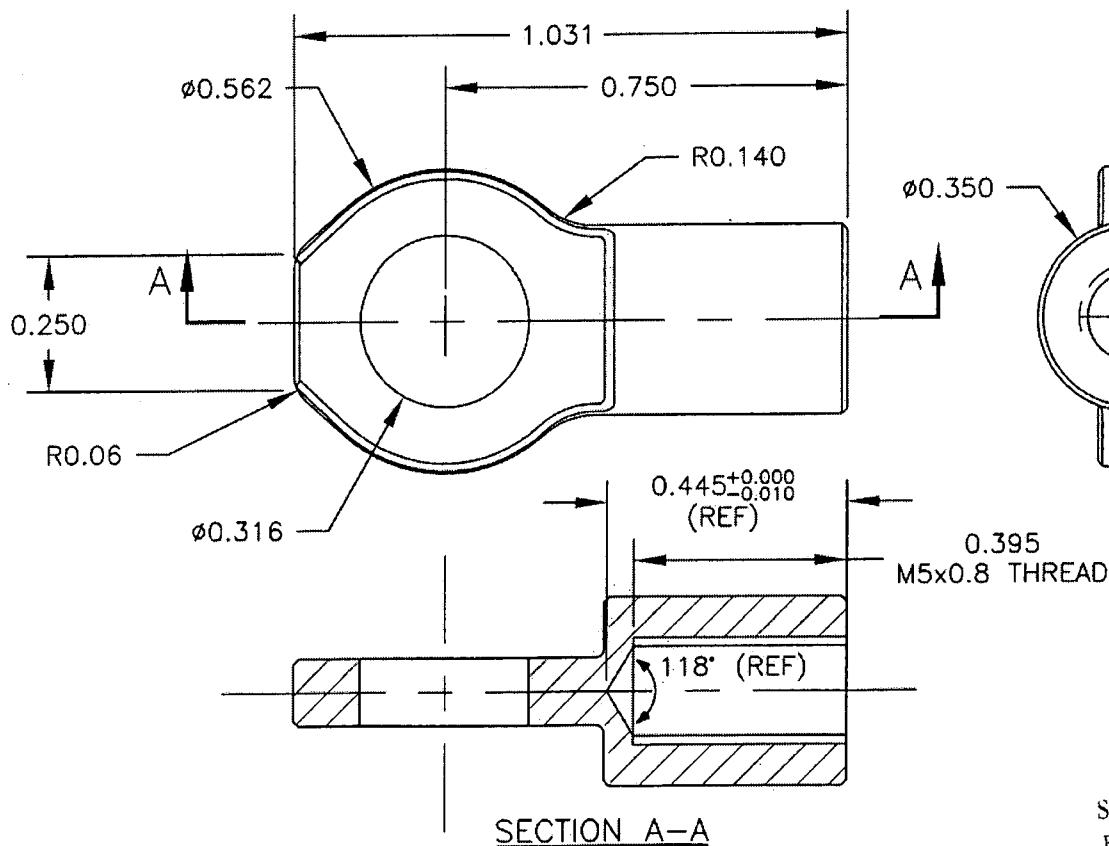
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
CJ-05-06-16

| DESIGN CP |          | DRAWN BY CP       | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |        |     |
|-----------|----------|-------------------|---|--------|-----|
| CHECKED   | APPROVED | DRAWING NO. D2807 |   | REV. C |     |
| DATE      |          | TITLE             |   | SCALE  |     |
| 05.05.25  |          | GAS SPRING        |   |        | 1:1 |
| A         |          | 00.11.03          | NEW ISSUE   |        |     |
| B         |          | 05.03.16          | ADD FINISH  |        |     |
| C         |          | 05.05.25          | CHANGE SPRING TO SS, ADD -3 LUG                   |        |     |

**DART**

|                      |                       |   |
|----------------------|-----------------------|---|
| DESIGN<br>CP         | DRAWN BY<br>CP        | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>MM</i> | APPROVED<br><i>MM</i> | DRAWING NO.<br>D2807                              |
| DATE<br>05.05.25     |                       | REV. C<br>SHEET 2 OF 2<br>SCALE<br>3:1            |

**RELEASED**  
05.06.16 *MM***D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *27151*

**INVOICE TO**

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ONTARIO  
K6A 1K7  
CANADA

DART AEROSPACE LTD  
SHIP WITH AE:57522 VIA  
FEDEX P-1 OVERNIGHT SVCE  
ACCOUNT NO: 15179324-0

DATE

A/C No. 20111

AREA  
46

~~CUSTOMER REF. No.~~

V.A.T. REGISTRATION No. GB 738 8577 71

W ORDER  
NUMBER

NUMBER  
QTY ALLOC  
XXXXXX

**QTY. SHIPPED**

50

BATCH No.

**SPECIAL INSTRUCTIONS**

| SHIP DATE | CARRIER CODE | WEIGHT | DESPATCH TICKET |
|-----------|--------------|--------|-----------------|
| 07JUN06   |              |        |                 |

888

**Arvin Motion Control Limited.**  
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E-mail - [info.amcl@arvinmeritor.com](mailto:info.amcl@arvinmeritor.com)  
Website: [www.camloc.com](http://www.camloc.com)

**YOUR ORDER WAS PACKED BY** . . . . .  
Certified that the whole of the supplies detailed herein  
have been inspected and tested and unless otherwise stated  
SIGNED \_\_\_\_\_

Certified that the whole of the supplies detailed hereon have been inspected and tested and unless otherwise stated conform in all respects with the contract/purchase order.

SIGNED

